

[illegible]

Page 1

Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**

Abstract

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/08 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

[illegible]

**Insp.
Stamp**

Revision Nbr

D3911

D

0.00

0.00

0.00

0.00

100

[illegible]

Bandsaw

Jeaspa Bandsaw

Memo

Cut blank to 2.885" long

.52 11/02/16

6

110

Abstract

HAAS 1

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FA917 & dwg,
FOLIO REV: AA
DWG REV: D

2-Deburr as required

0.00

SL 11/02/28

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66231

February 8, 2011 8:43:16 AM



Page 2

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 2/08/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/02/28

(6)



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

amr 11/03/01



QC

Memo

0.00

Quality Control

6

140

Identify as per dwg & Stock Location: 09/

0.00



Packaging

Memo

0.00

Packaging

Pau 3/01 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66231

February 8, 2011 8:43:16 AM



Page 3

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 2/08/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01

CL 11/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:43:16 AM

Page 1

Work Order ID: 66231



Parent Item: D3911-3



Parent Item Name: Aft Eyebolt Receiver

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 6.00


Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750 		Purchased	No			100	f	13.7665	0.26	1.642105			

303 BAR 2" X 1.750"



SL 11/02/16

Location

Loc Qty

Loc Code

MAT

13.76646

1.65

115047

13.76646

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66231
Description: Aft Eyebolt Receiver		Part Number:	D3911-3
Inspection Dwg: D3911	Rev: C	Page 1 of 1	

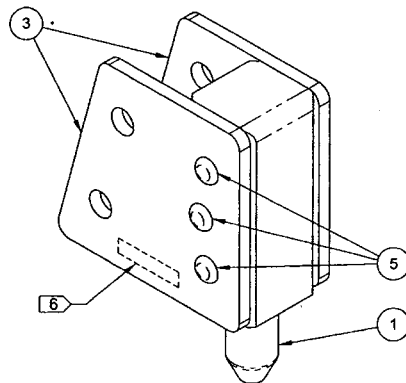
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.252	✓		vern-JL-3	
1.250	+/-0.010	1.246	✓		"	
0.09 X 45°	+/-0.030 X 0.5°	0.085 X 45°	✓		"	
1.00	+/-0.030	.999	✓		"	
0.500	+/-0.010	.500	✓		"	
R0.13	+/-0.030	.130	✓		R-G	
Ø0.129	+0.005/-0.001	.129	✓		"	
R0.19	+/-0.030	.188	✓		R-G	
0.960	+/-0.010	.963	✓		"	
0.09 X 45°	+/-0.030 X 0.5°	.100 X 45°	✓		"	
Ø0.257	+0.006/-0.001	.258	✓		"	
0.350	+/-0.010	.350	✓		"	
2.76	+/-0.030	2.760	✓		"	
1.110	+/-0.010	1.110	✓		"	
0.800	+0.000/-0.010	.795	✓		"	
0.225	+/-0.010	.224	✓		"	
1.80	+/-0.030	1.795	✓		H-G	
Ø0.65 .825	+0.010 +/-0.030	.821	✓			
ØK 0.625	+0.010 +/-0.010	.626	✓			
0.09 X 45°	+/-0.030 X 0.5°	.100 X 45°	✓			
Ø0.734	+0.010/-0.000	.736	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	11/02/28	Date:	11/03/01	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	<i>[Signature]</i>

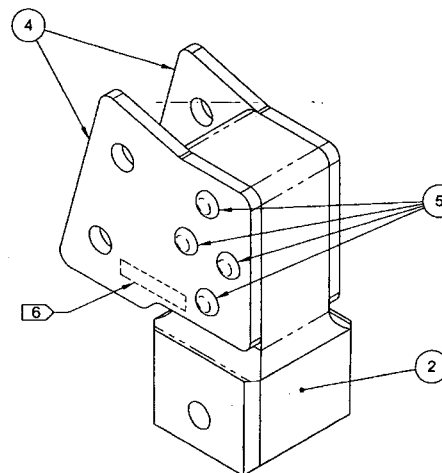
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

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WITHOUT NOTICE
WORK ORDER
NO. 66231
C211/02/08

RELEASED
2010-08-06

D	0.825 +0.000/-0.010 WAS 0.65 (B1-2).	MB	10.06.22
C	BOM: QTY (2); D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3911	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
DATE	10.06.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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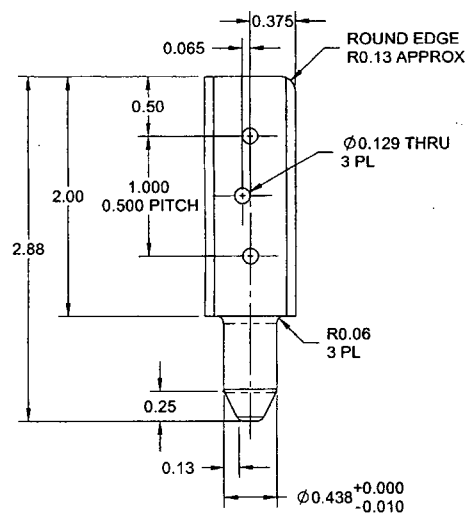
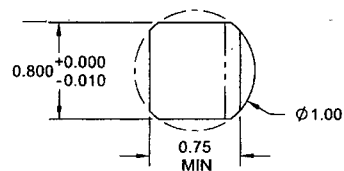
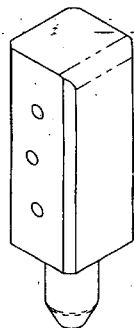
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D

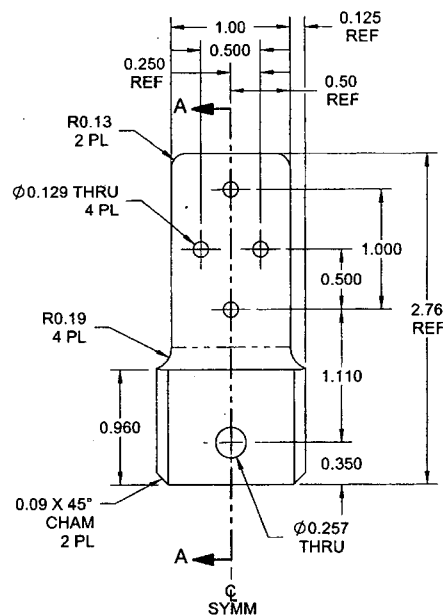
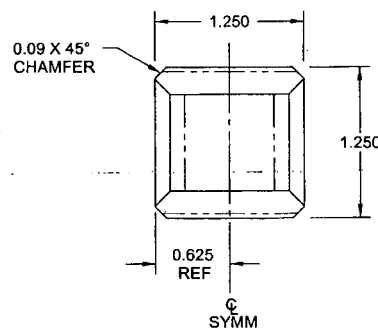
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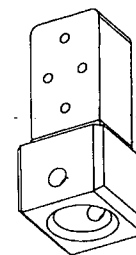
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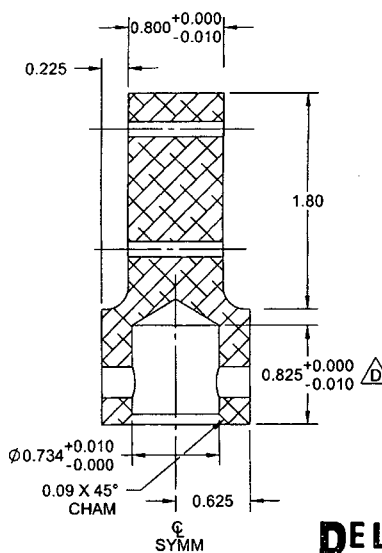
D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66231



SECTION A-A

RELEASED
2010-08-04
MDO

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.71 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3911	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR. --	<i>[Signature]</i>	AFT HARDPOINT, BASKET	NTS
DATE	10.06.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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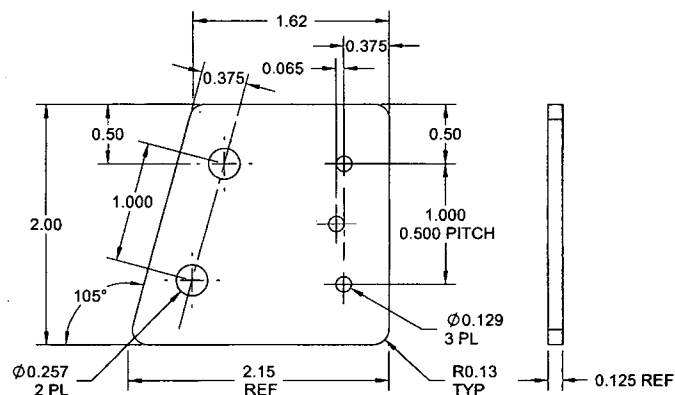
4

3

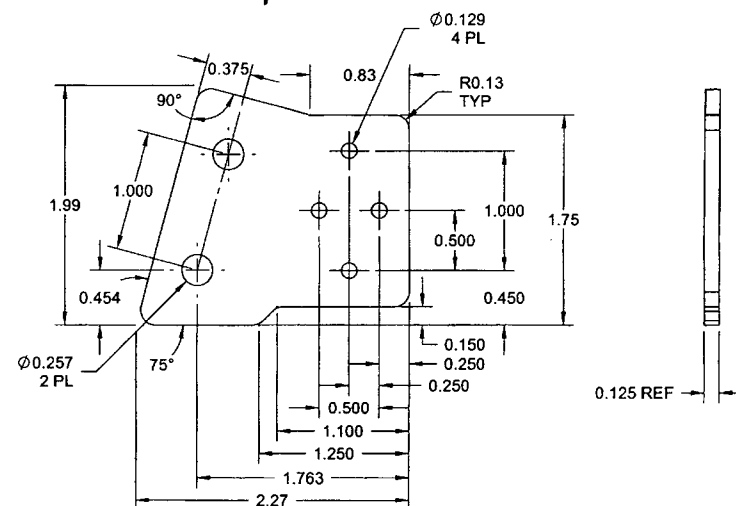
2

1

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WORK ORDER
NO. 66231



D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT--5: 0.13 lbs
-7: 0.13 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3911	SHEET 3 OF 3
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RELEASED
2010-08-01
M/B